

ASAD

Date: Friday, 29/08/2008 11:38:16 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 41664  
 Estimate Number : 10777  
 P.O. Number :  
 This Issue : 29/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3463042  
 Drawing Number : D3463 REV.B  
 Project Number : N/A  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : B  
 Material :  
 Previous Run : 38823 Due Date : 05/09/2008 Qty: 2 Um: EACH  
 Written By :  
 Checked & Approved By : JLD 08-8-29  
 Comment : EST-REV. A 05.11.18 new issue EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	238806	SS DOWEL PIN 1" LONG
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-806	SS DOWEL PIN 1" LONG	M105037✓

M105037✓

Pl 08-09-02

2.0	D34533	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-3	Clevis	39462

Batch

B35880\* 3453-5

Pl 08-09-02

3.0	D34637	Drag Arm
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-7	Drag Arm	35882✓

Batch

B35882✓

Pl 08-09-02

4.0	D34631	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-1	Arm	35881✓

Batch

35881✓

Pl 08-09-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 29/08/2008 11:38:16 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41664

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3463-3 Step

Batch

B434120-2 → 1 ✓

B39464 → 1 ✓

*Pl 08-09-02*

6.0

D34635

End Cap



Comment: Qty: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description  
2 D3463-5 Step Flat Pattern

Batch

B34121 ✓

*Pl 08-09-02*

7.0

D34535

Plug



Comment: Qty: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3453-5 Plug

Batch

B35879 \*

*Pl 08-09-02*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

*Pl 08-09-02*

*(P15) →*

*(X2)*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION.

*PD 08-09-03 (2)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*See 08/09/04 (42)*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:


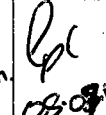


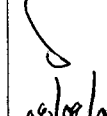

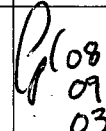

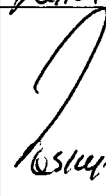
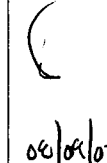

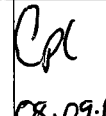


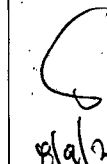
8:51

*FL 08/09/04*

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-042 PAR #: N/A Fault Category: Prod/Ins. Large NCR: (Yes) No DQA: D Date: 08/09/10  
 QA: N/C Closed: D Date: 08/09/11

NCR: <u>41664</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/3	A g.o	During welding inspection it was found on both (qty 2) steps that the D3463-3 step was welded flush to the D3463-1 Arm.		<ul style="list-style-type: none"> <li>cut off the D3463-3/1-5</li> <li>grind to bring flush &amp; smooth</li> <li>Pick new D3463-3 B39464</li> <li>2x D3463-5B 3463-5</li> <li>and re-weld into position as per drawing on QTY 2</li> <li>Ref: M106762 A/R</li> </ul>	 08-09-03	 08/09/04	 08/09/03	 08/09/03
		R.C. welder masep read the drawing thought it was supposed to be 0.030" instead of 0.30".			 08-09-03	 08/09/04	 08/09/03	 08/09/03
8/1/3	# g.o	During QC inspection it was found that D3463-7 was welded in wrong position QTY 2 R.C. welder <del>did not</del> was welded		<ul style="list-style-type: none"> <li>Remove the D3463-7 Arm and pick a new one B 35882</li> <li>Qty 2</li> <li>re-weld into position as per drawing.</li> <li>Ask questions if not sure</li> </ul>	 08-09-04	 08/09/04	 08/09/03	 8/1/3

NOTE: Date & initial all entries incorrectly in Syg.

Lack of attention/knowledge

Date: Friday, 29/08/2008 11:38:16 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41664

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

(PD) →

OVEN TEMPERATURE: 400°

FINISH TIME: 9:20

FX 08/09/04 (2)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M108496



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

98 08-09-04 (22)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/09/04

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 205

8/9/4

(2X)

SB

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10

Job Completion



MF 08-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

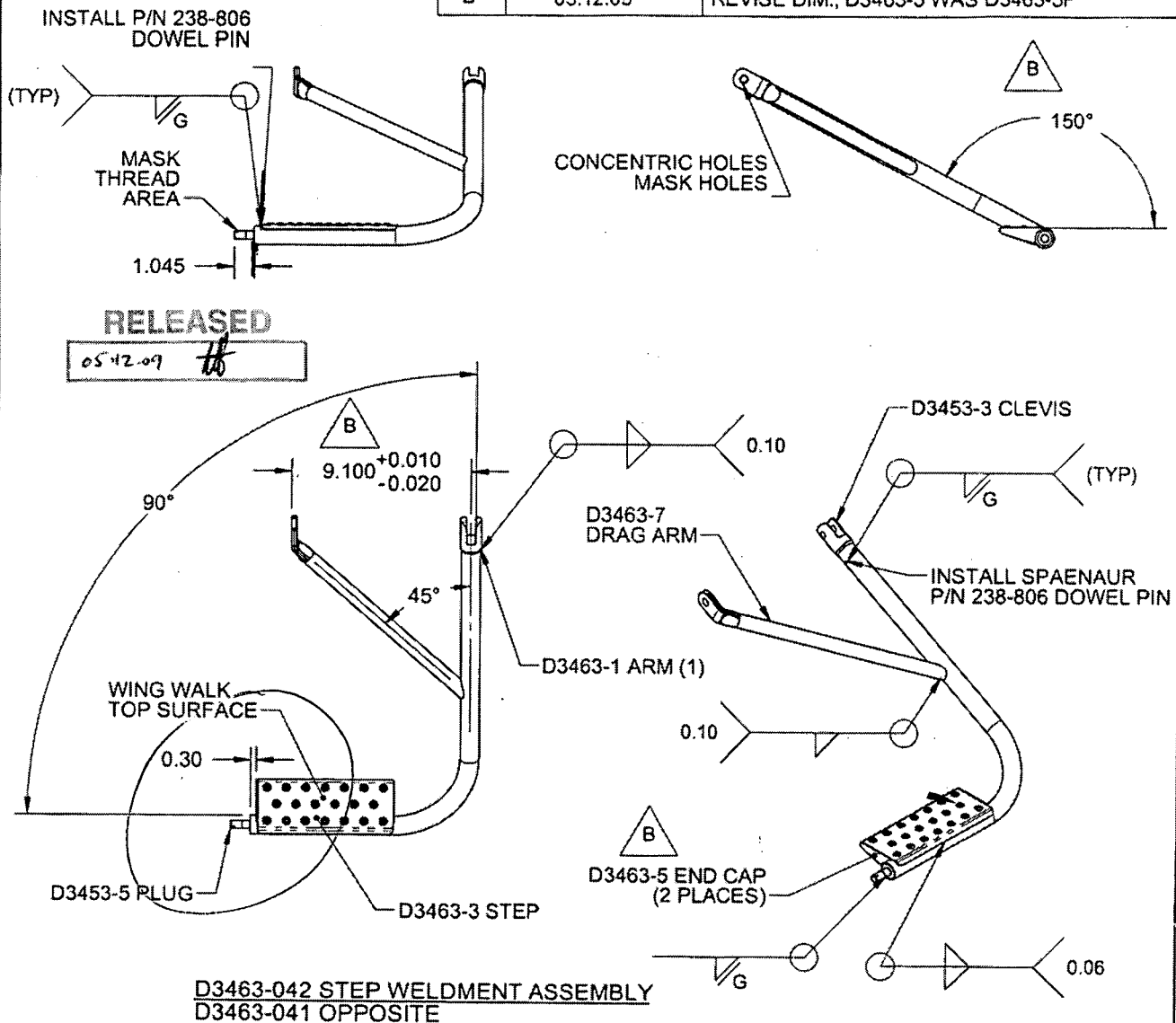
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/04	11.	Marker mark found HWDag Powder coat & Dushay QC 3 ins pecten. It wasn't clear enough.	<i>[Signature]</i>	Scuff affected area with 320 grit sand paper.	FX 08/09/04 <i>[Signature]</i>	08/09/04 <i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
			<i>[Signature]</i>	Re Powder coat as per QS 7005	FX 08/09/04 <i>[Signature]</i>	08/09/04 <i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
								<i>[Signature]</i>

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b> SCALE 1:8		
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

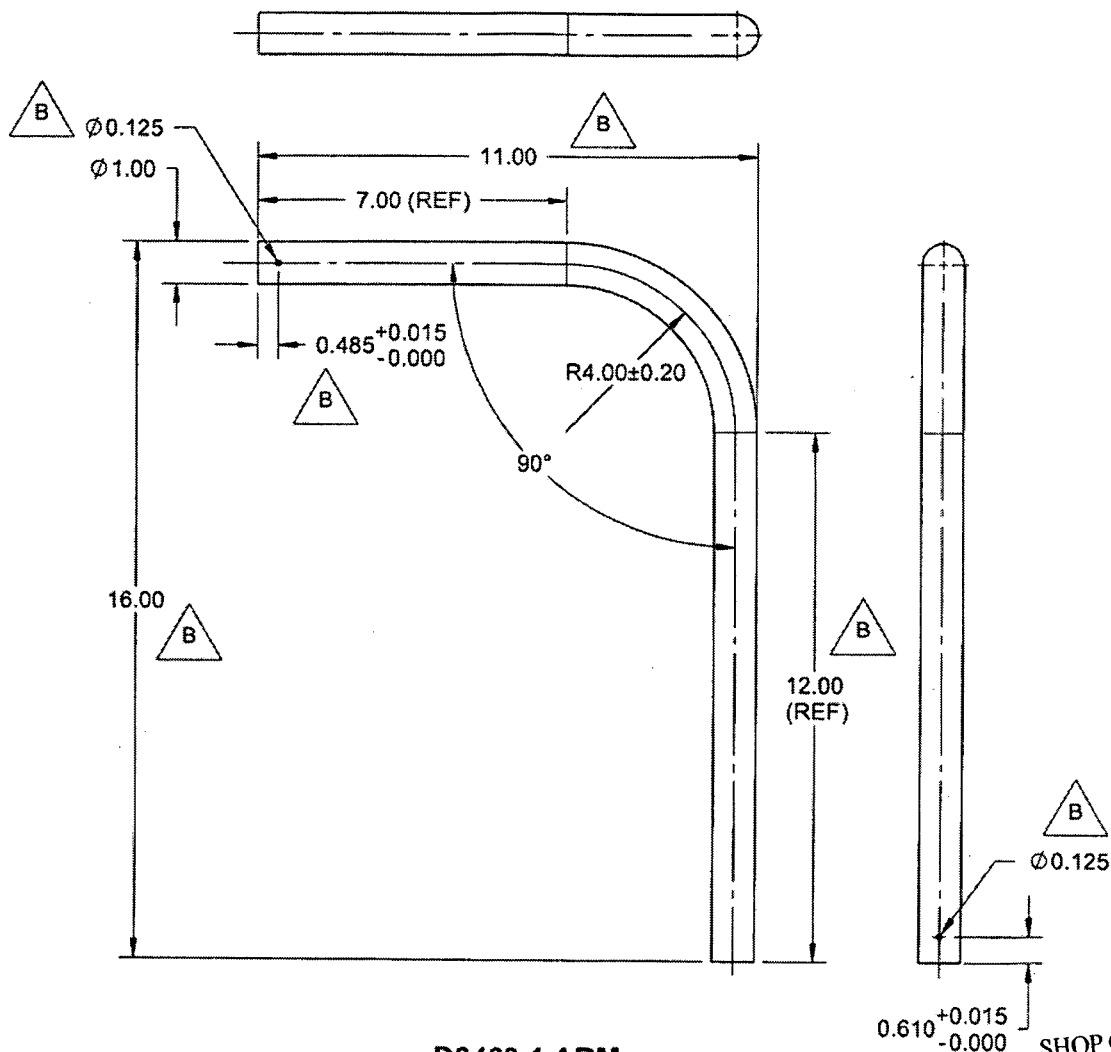
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3463</b>	REV. B SHEET 2 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:4

**RELEASED**05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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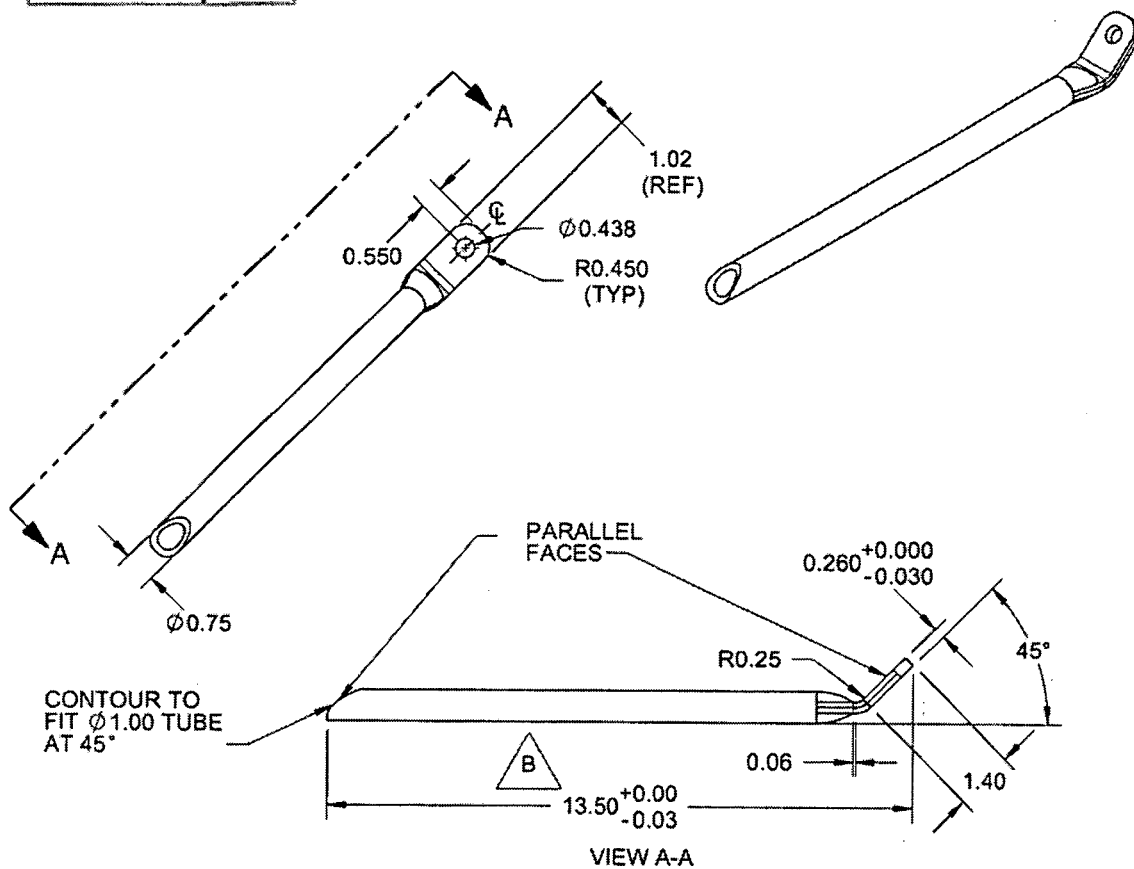


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DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:4

**RELEASED**

05.12.05 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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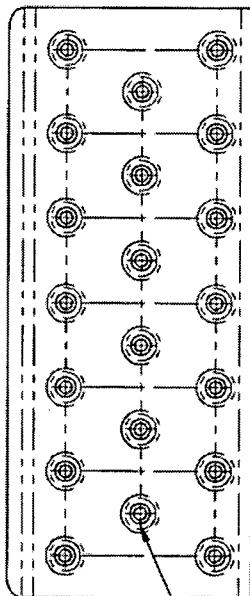
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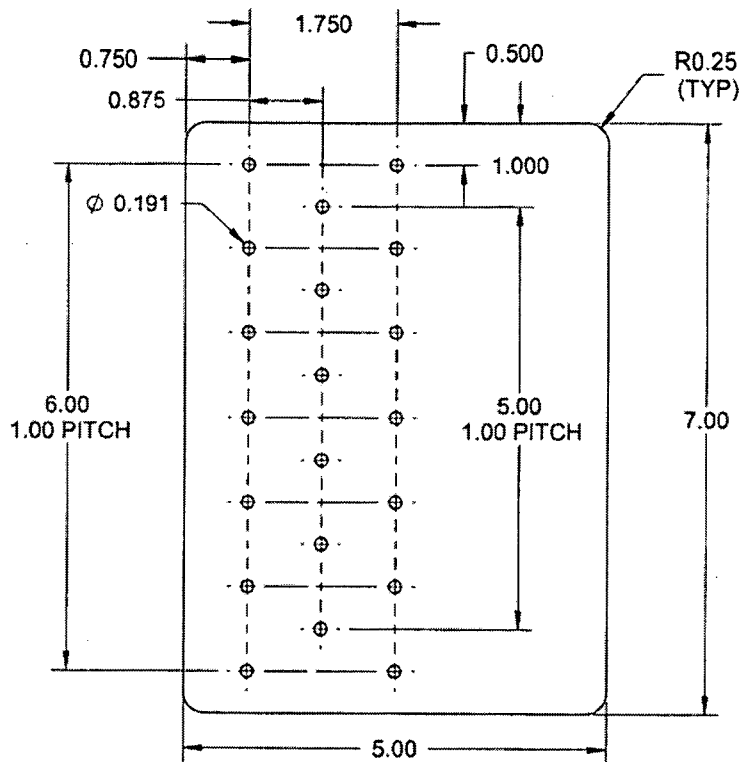
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CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 4 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:2

**RELEASED**

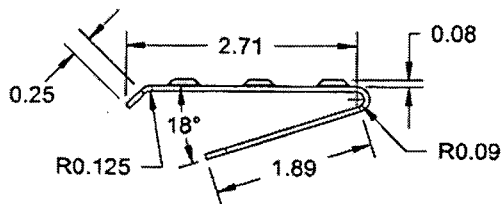
05.12.05 #



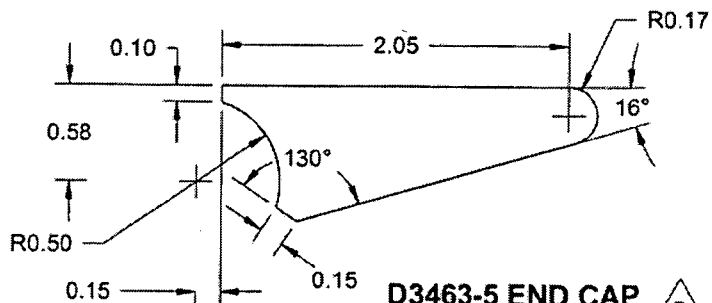
FORM USING  
D3463-3T1



**D3463-3F FLAT PATTERN**



**D3463-3 STEP**



**D3463-5 END CAP**

SCALE 1:1 SHOP COPY

RETURN TO  
ENGINEERING

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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